

Ship July 14

Dart Aerospace Ltd.

Date: Thursday, 6/29/2006 3:53:03 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP WELDMENT
Job Number : 27804	
Estimate Number : 10721	
P.O. Number : N/A	Part Number : D34637
This Issue : 6/29/2006 S.O. No. : N/A	Drawing Number : D3463 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 27536	Material : N/A
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 7/12/2006 Qty: 6 Um: EACH
Checked & Approved By : <i>06 06 29</i>	
Comment : EST REV A 05.11.18 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	Inventory
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Comment: Qty.: 1.0000 f(s)/Unit Total : 6.0000 f(s)  
AISI 304 SS seamless tubing 0.750 OD X 0.120 wall  
(M304TR0750W120)  
Batch: *17101580*

*FF 06-07-14* 6

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Drill hole as per dwg D3463
- 2-Deburr
- 3-Cut to 13.875"
- 4-Bend end as per dwg D3463

*SB 06/07/17* 6

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*BC 06-07-17* 6

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

- 1-Mill as per dwg D3463
- 2-Deburr

*06/07/17* 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/29/2006 3:53:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27804

Part Number: D34637

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SG* 06/07/17

6

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SG* 06-07-17

6

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *214*

*PD* 06-07-18

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*H* 06.07.18

Job Completion



*U* 06-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

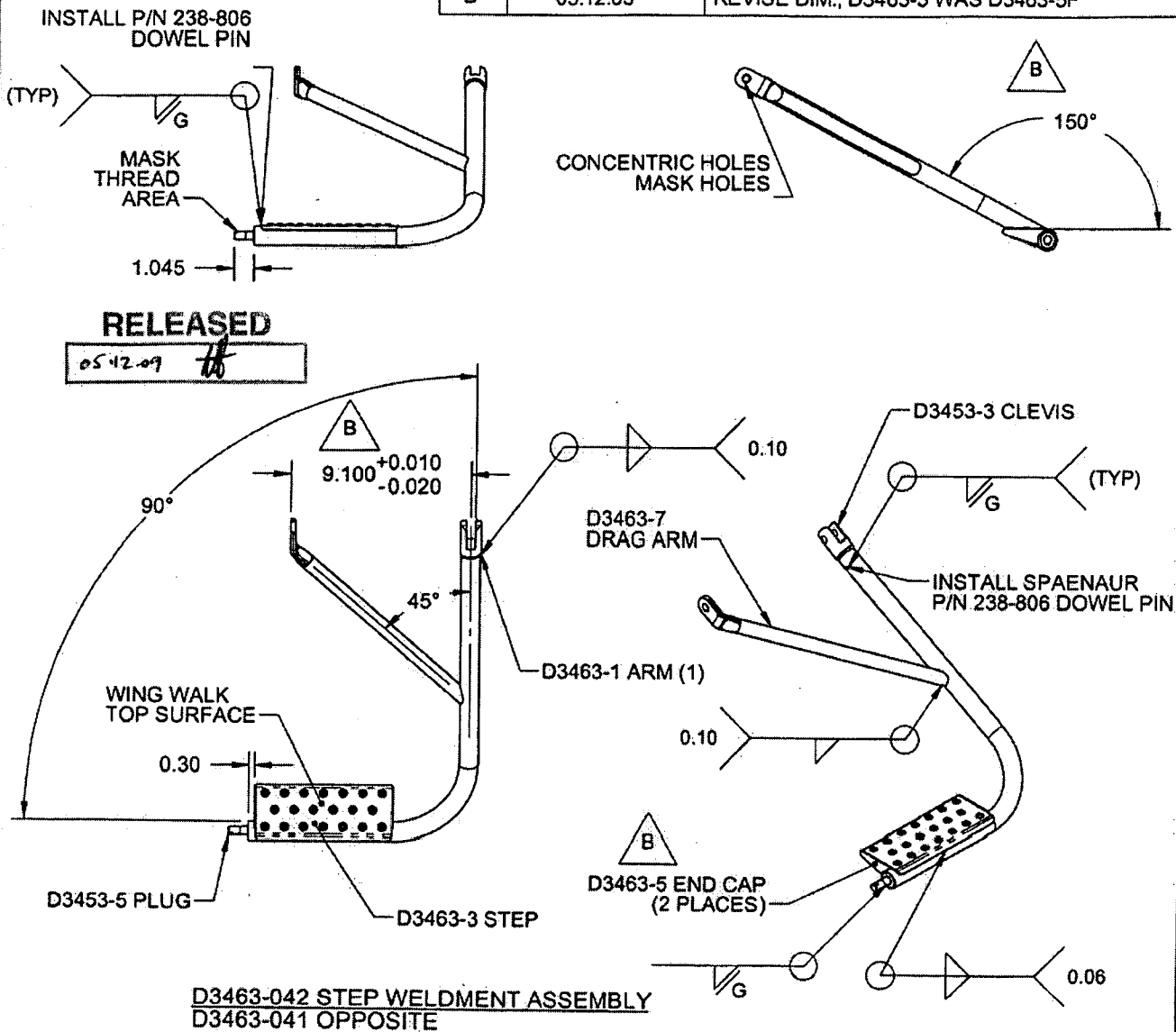
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WORK ORDER  
NO. 27804

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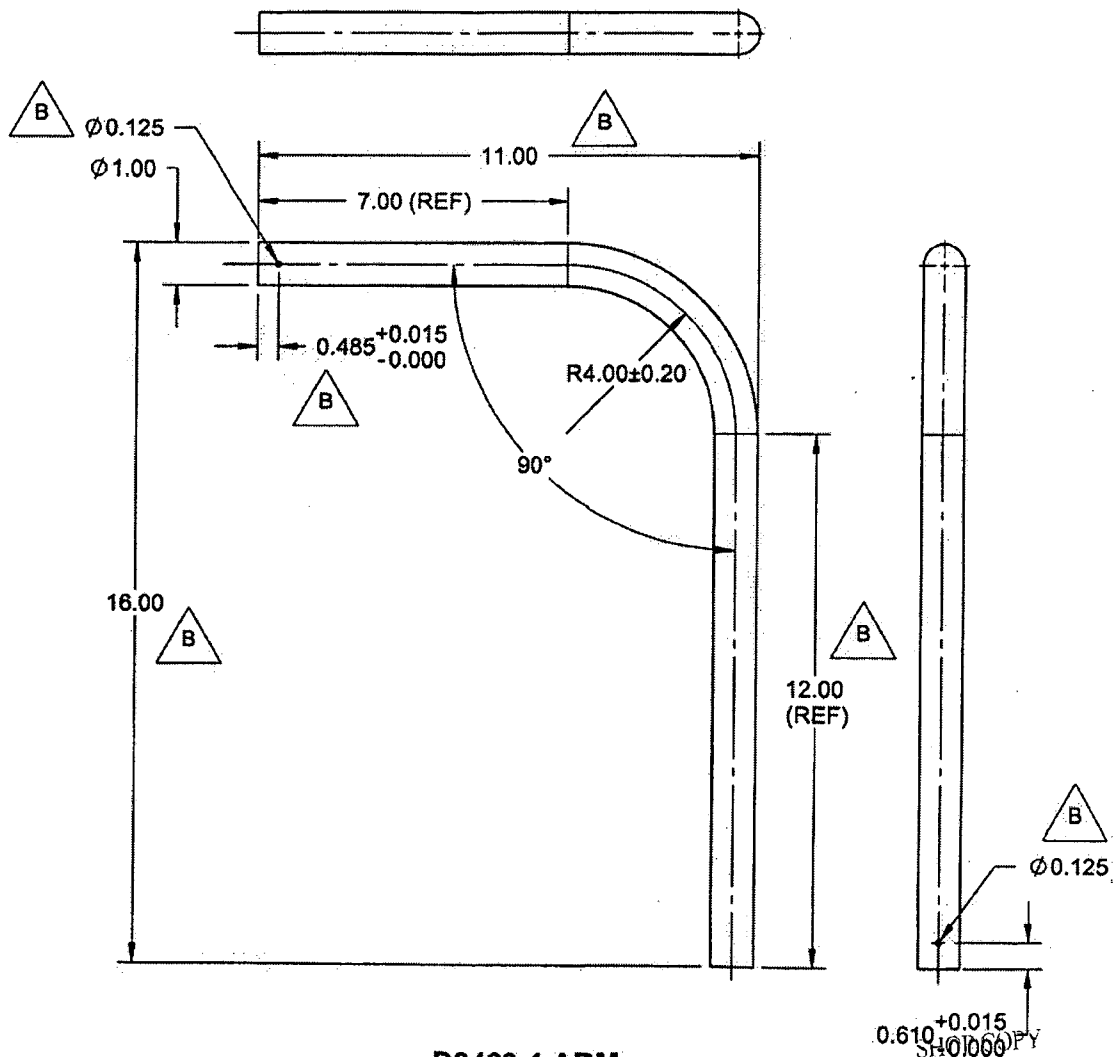
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

**RELEASED**

05.12.09 [Signature]

**D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

0.610+0.015  
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WORK ORDER

NO. 27804

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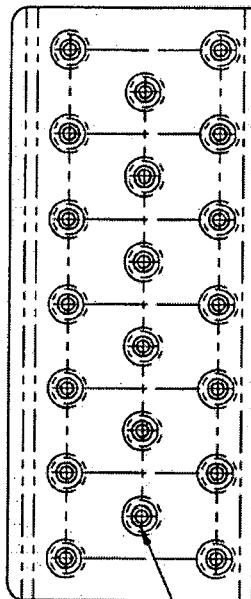
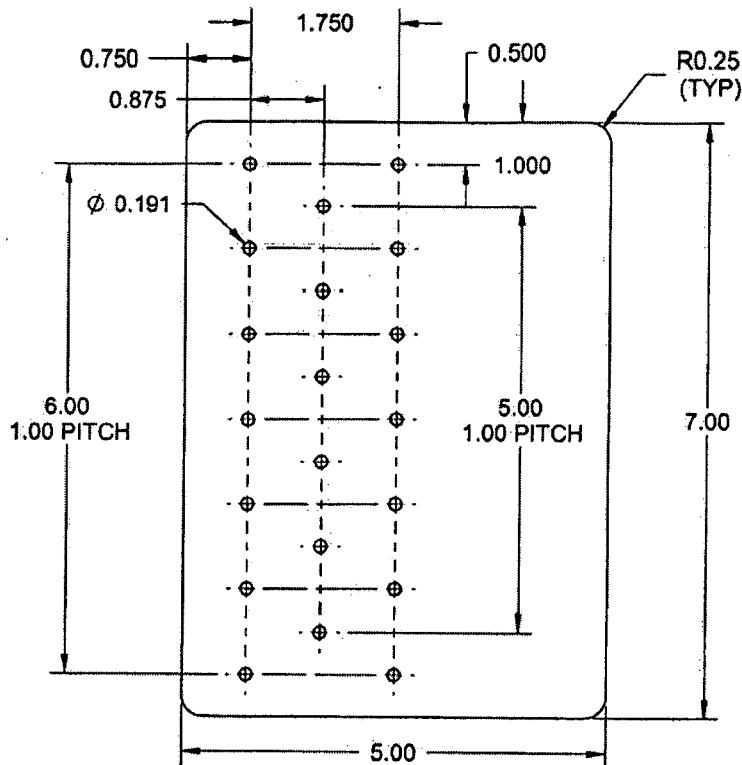
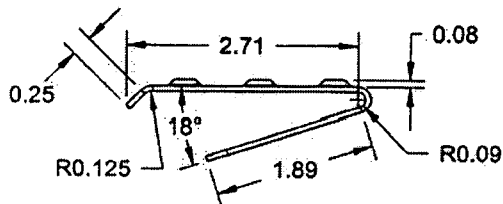
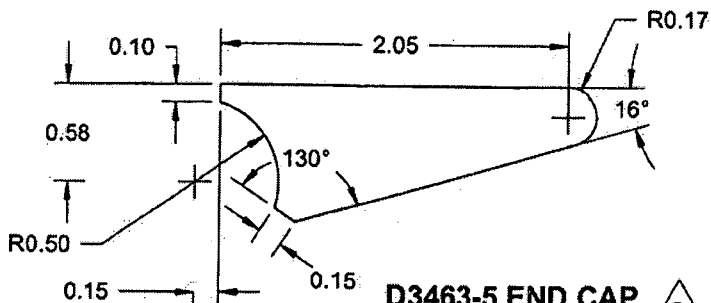


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CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 4 OF 4
DATE <b>05.12.05</b>	TITLE <b>STEP WELDMENT</b>		SCALE 1:2

**RELEASED**

05.12.09 #

**FORM USING  
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**

SCALE 1:1

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NO. 27804

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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